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a frame, with the longitudinal direction in the vertical position and placed side by side until the frame is filled up, and an adhesive is filled into the gaps between the optical fibers 140 and solidified, and the frame is removed, the frame of a specific form being open on upper side and on the down side. The specific form of the frame is a form required for image reading apparatuses such as copying machine using condenser lens 14 to perform their intrinsic functions and is generally a strip perpendicular to the document carrying direction. Furthermore, as shown in FIG. 27, if necessary for molding, individual optical fibers 140 or fiber bundles 144 may be sandwiched in the frame between a substrates 142 of opaque glass, resin or the like so that the substrates 142 and the individual optical fibers 140 or fiber bundles 144 are bonded to each other.

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